

Work Order ID 67471

Tuesday, March 22, 2011 1:44:25 PM

Page 1

Item ID: D4079-1

Accept

Revision ID:

Item Name: Clamp Half, Attachment

Start Date: 3/22/2011 Start Qty: 16.00

Required Date: 3/30/2011 Req'd Qty: 16.00

Reference:

Approvals:

Process Plan: mf

Date: 11-03-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4079

B

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut blank 2.750" long

0.00

SL 11/03/22

16

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA931

Folio rev: 4A

Dwg Rev: B

0.00

mk 11/03/29

16

Deburr

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67471

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Item ID: D4079-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp Half, Attachment

Start Date: 3/22/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

onk 11/03/29

16

✓

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Jm 11/03/29

16

✓

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

16

BR 11-3-29

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Powder Coating

M115128

Memo

START: 11:15

QUANT. 3200

FINISH: 11:45

16 BL 11-3-30.

160

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

16 0 All 4/05/30

170

Identify as per dwg & Stock Location: 12/57

0.00



Packaging

Packaging

Memo

0.00

16 11/3/30 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 67471

Tuesday, March 22, 2011 1:44:25 PM

Page 4

Item ID: D4079-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Clamp Half, Attachment

Start Date: 3/22/2011 Start Qty: 16.00

Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 16.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/30

ME

11-03-30

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, March 22, 2011 1:44:20 PM

Page 1

Work Order ID: 67471



Parent Item: D4079-1



Parent Item Name: Clamp Half, Attachment

Start Date: 3/22/2011

Required Date: 3/30/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	35.6910	0.23	3.873684			



6061-T6 Bar 2.00 x 2.00



SL 11/03/22

Location

Loc Qty

Loc Code

MAT009

35.691

113006

14.8617

113123

11.8293

13085

9

3.9

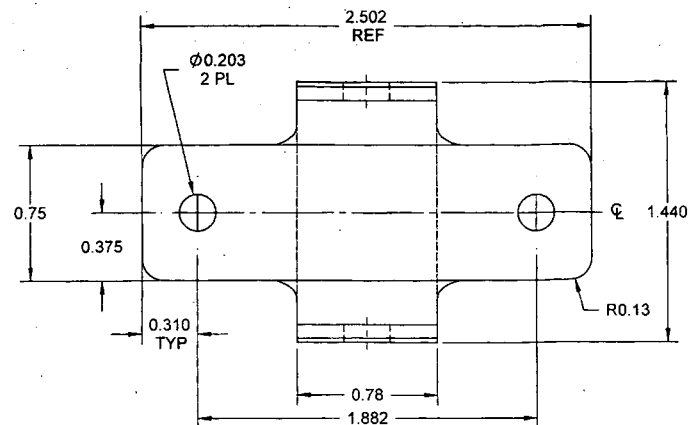
W/O:		WORK ORDER CHANGES					
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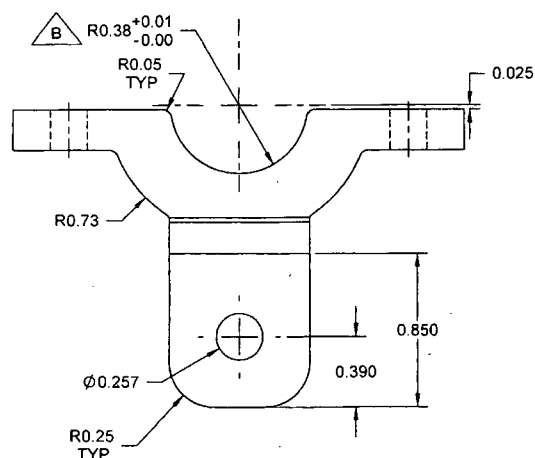
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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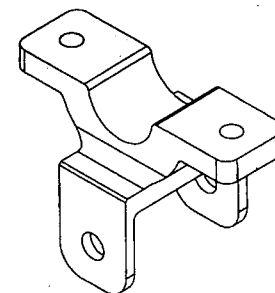
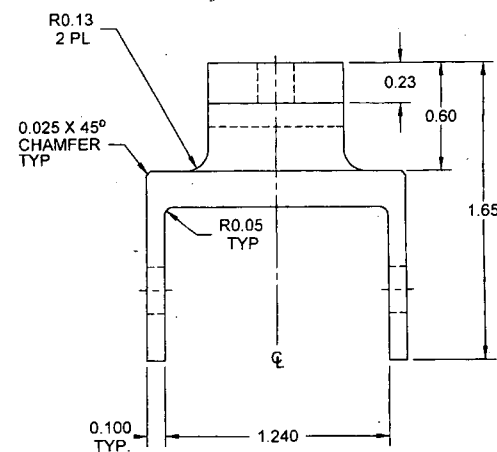
NOTE: Date & initial all entries



GRAIN
DIRECTION



D4079-1 CLAMP HALF, ATTACHMENT



#67471

RELEASED
2010-09-07
MP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4079-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs

B	R0.38 WAS R0.48	JB	10.07.30
A	NEW ISSUE	JB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN		JB	
DRAWN		JB	
CHECKED		JB	
MFG. APPR.		JB	
APPROVED		JB	
DE APPR.		JB	
DATE	10.07.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4079	REV. B SHEET 1 OF 1
TITLE CLAMP HALF, ATTACHMENT	SCALE NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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DART AEROSPACE LTD		Work Order: 67471
Description: Clamp Half, Attachment		Part Number: D4079-1
Inspection Dwg: D4079	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.502	+/-0.010	2.501	/		vern. 3	
Ø0.203	+0.005/-0.001	0.204	/		"	
0.75	+/-0.030	0.746	/		"	
0.375	+/-0.010	0.374	/		"	
0.310	+/-0.010	0.310	/		"	
1.882	+/-0.010	1.882	/		"	
0.78	+/-0.030	0.780	/		"	
R0.13	+/-0.030	0.13	/		R-G	
1.440	+/-0.010	1.437	/		"	
R0.38	+0.010/-0.000	0.383	/		H-G	
R0.050	+/-0.010	0.050	/			
R0.73	+/-0.030	0.73	/			
Ø0.257	+0.006/-0.001	0.257	/		"	
R0.25	+/-0.030	0.25	/		R-G	
0.390	+/-0.010	0.389	/		"	
0.850	+/-0.010	0.850	/		"	
0.025 x 45°	+/-0.010 x 0.5°	0.025 x 45°	/		"	
0.100	+/-0.010	0.100	/		"	
R0.05	+/-0.030	0.06	/		R-G	
1.240	+/-0.010	1.239	/		"	
1.65	+/-0.030	1.651	/		H-G	
0.60	+/-0.030	0.600	/		"	
0.23	+/-0.030	0.225	/		"	
0.025	+/-0.010	0.027	/		"	

Measured by: SL	Audited by: [Signature]	Preliminary Approval:
Date: 11/03/23	Date: 11/03/23	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	[Signature]

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